

Work Order ID 57715

April 14, 2010 10:11:16 AM



Page 1

Item ID: D3566-1

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 14/04/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3566

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B 10-4-14

(37)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-4-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sokolovs

counts
X36

H

Pto ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3566-1 PAR #: N/A Fault Category: Im. fab NCR: (Yes) No DQA: N Date: 10.04.27
 Resolution: JARAP Disposition: Scrap QA: N/C Closed Date: _____

NCR: <u>57715</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/15	#100	Found Qty x1 bracket with the 300"x300" holes all cut to .500"x.300". RL made in water jet.	<u>JB</u> <u>05/12</u>	Scrap + Destroy Qty x1 no replace extras were made	<u>JB</u> <u>10-4-15</u>	<u>S</u> <u>10/4/15</u>	<u>JB</u> <u>05/12</u>	<u>S</u> <u>10/04/15</u>

NOTE: Date & initial all entries

Work Order ID 57715

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Page 2

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Item Name: Gasket

Start Date: 14/04/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

HPB

0.00



Packaging

Memo

0.00

Packaging

10-4-15

36x SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/1998
MF 10-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:11:20 AM

Page 1

Work Order ID: 57715

Parent Item: D3566-1

Parent Item Name: Gasket


Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MNEO60S.063		Purchased	No			100	sf	308.5000	28.7684	36,		
												
NEOPRENE SHEET 0.063												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT052

114176

308.5

308.5

114176

1810-4-14

37

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57715
Description: Gasket		Part Number:	D3566-1
Inspection Dwg: D3566	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.110	X			
18.00	+/-0.030	18.00	X			
12.10	+/-0.030	12.10	X			
2.43	+/-0.030	2.437	X			
6.00	+/-0.030	6.00	X			
1.40	+/-0.030	1.404	X			
0.30	+/-0.030	.307	X			
0.30	+/-0.030	.305	X			
0.063	+/-0.010	.061	X			
Ø0.188	+0.005/-0.001	.190	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-4-14	Date: 10/04/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	EE

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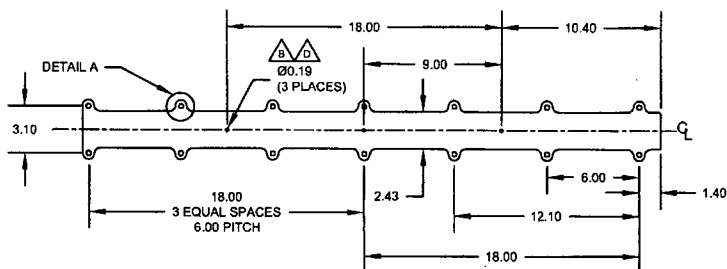
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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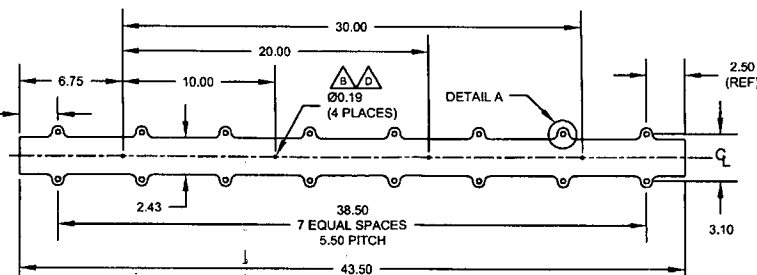
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

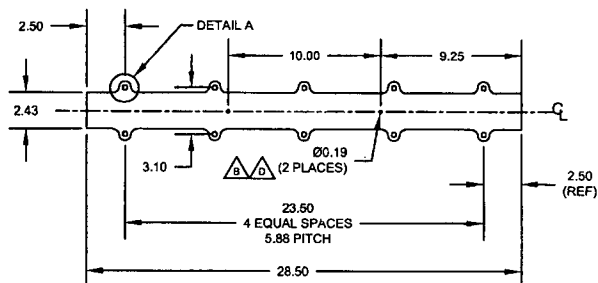
WITHOUT NOTICE
WORK ORDER
NO. 57715
10-4-14



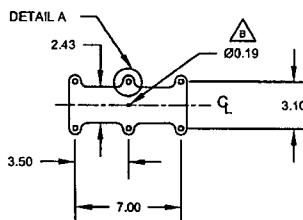
D3566-1 GASKET



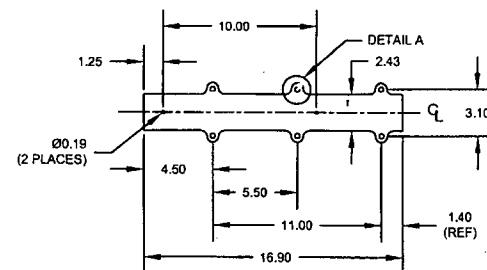
D3566-5 GASKET



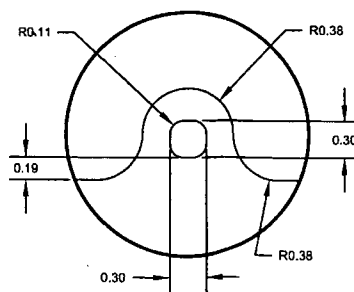
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



DETAIL A
SCALE 1:1

WEIGHTS:
D3566-1 0.29 lbs
D3566-5 0.36 lbs
D3566-7 0.24 lbs
D3566-13 0.07 lbs
D3566-15 0.15 lbs

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT C

RELEASED

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3566 GASKET REV. C SHEET 1 OF 1 SCALE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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